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RBA9825
Job Sheet 190148



Part No: RBA9825

Job Qty: 12 pcs

Part Name: Pitch Bearing Wrench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/5/19

Job Tracking No:

Due Date: 3/27/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 12561*

Note: DWG RBA9825 Rev.2 IPP Rev. A 19.01.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Omax - 1	1 pcs	3/27/19	3/27/19	0.00	0.10	Waterjet - Omax	<i>19/02/15</i>
110	QC 2	1 pcs	3/27/19	3/27/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	<i>19/02/15</i>
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	
							QC 2 - 8	

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120	QC 8	1 pcs	3/27/19	0.00 0.00	QC 2 - 66	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
150	Outsource - 1 - Heat Treat	1 pcs	3/27/19		MEI001-VC	
180	Outsource - 13 - Zinc Plating	1 pcs	3/27/19		GRO002-VC	
190	Packaging 2-2 - Receive - B4B	1 pcs	3/27/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	

200 QC 6	1 pcs	3/27/19	0.00 0.00	Packaging 2 - 36 - B4B	
				QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
210 Packaging 3-1 - Stock - B4B	1 pcs	3/27/19	0.00 0.00	QC 6 - 61	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220 QC 21 - FG	1 pcs	3/27/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Part Op 100 - 1-Cut as per DWG. DWG. Rev: 2 PROG. Rev: 2 2-Deburr if necessary
 Descriptions: 110 - QC2 Waterjet-4 (QC2- Inspect parts off machine FAI/FAIB)
 120 - QC8-7 (QC8- Inspect parts - second check 1-Engrave T/N and/or P/N number using MARKTRONIC engraver as per DWG.
 150 - 1-Issue P/O; 40-50 RC 38-44 2-Bead blast 3-Material type; 01 4- Certificate of Conformity is required
 NOTE DROP SHIP TO FINISHER HEAT TREAT to ship directly to SURFACE FINISH***
 180 - -Issue P/O ; 40-50 -Zinc plate, ASTM B633 TYPE 1 SC2 -Color; Clear -Material type; 4140 -Certificate of Conformity is required
 190 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs) Receive
 200 - QC6 (QC6- All purchased or subcontracted products)
 210 - Packaging3-2 (Identify as per dwg & Stock Location:) Identify and Stock
 220 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1018S.188	M1018S.188 see mat'l MT-HRS-P-.188	.0110 sf (0.11 ea)	100-Waterjet - Omax - 1	

~~MT 4140 S 0.187~~

(0.125)

9516K613

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	M1018S.188	0	10	0

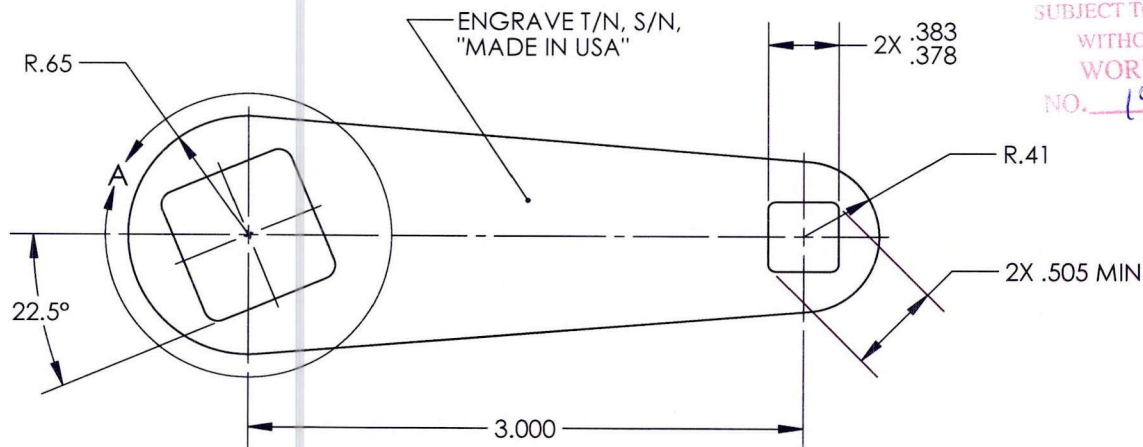
Part Specifications

Specifications could not be found.

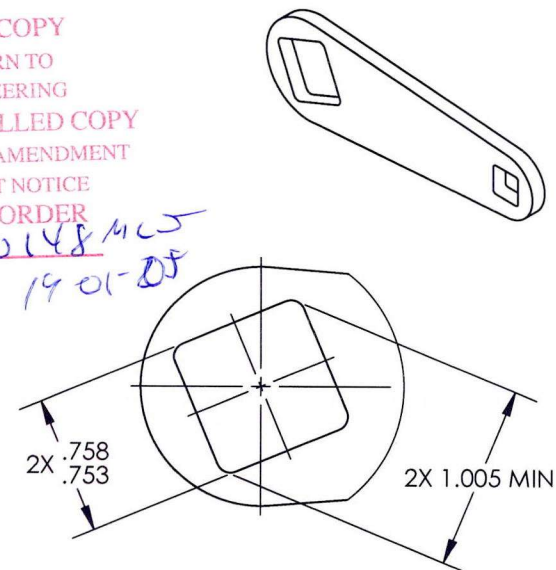
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REVISIONS							
REV	ECR	DESCRIPTION			DATE	INITIAL	APPROVED
2	16-0225	CH'D DIMS WAS .188 IS .19, WAS .760 SQ IS 2X .753-.758, WAS .380 SQ IS 2X .378-.383, ADDED DIMS 2X 1.005 MIN, 2X .505 MIN, ADDED ENGRAVE NOTE T/N, S/N, "MADE IN USA". CH'D MAT'L WAS 4130/4140 IS 4140/4142, CH'D FINISH WAS CAD YELLOW IS ZINC PLATE ASTM B633 TYPE I SC2, ADDED OEM REF, ADDED USED ON MODELS.			11/18/2016	DPD	JAG



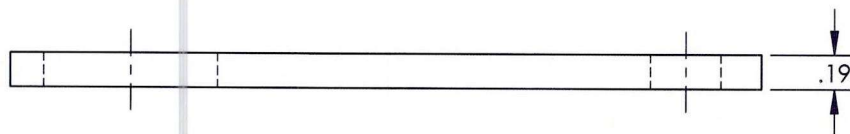
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 190148 MJS
1901-05



DETAIL A

NOTES:

- REFERENCE 369A9825
- USED ON MODELS:
MD500, MD500D, MD500E, MD520N, MD530F



DART AEROSPACE	
TITLE PITCH BEARING WRENCH	
DWG NO. RBA9825	REV 2
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 38-44	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .010 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .03 ANGLES ± 1°
DRAWN BY: WEIL	.X ± .1 SURFACES ± 125°
CHECKED:	1. BREAK ALL SHARP EDGES
OPPS APPR:	.015 x 45° OR .015R
QA APPR:	2. DIMENSIONAL LIMITS APPLY
APPROVED:	AFTER PLATING
	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	SEE NOTE 2
SCALE 1:1	DATE 4/25/1999
	SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
				1	PITCH BEARING WRENCH	4140/4142	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>190148</u> Part No. <u>RB49825</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : <u>19-02-19</u>	Sequence #: <u>110-QC2</u>	QTY Affected : <u>6</u>		MRB (QSI042)	
Description Work Order Deviation			Disposition		
<u>- MATL IS 1018, SHOULD BE 4140/4142 AS PER DWG.</u>			<u>- SCRAP</u>		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
			 <u>19-02-19</u>		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details: <u>WRONG MATERIAL.</u>			

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. <u>RBA9825 REV. 2</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042) FEB 7, 2019	
Description Work Order Deviation		Disposition		Completed By	
MATERIAL WAS 4140/4142, MATERIAL IS McMaster#9516K613 OR EQUIV. 01 HEAT TREAT WAS RC 38-44, HEAT TREAT IS RC 40-50		THIS DEVIATION IS ACCEPTABLE THE FIT, FORM, AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED		Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause		FAULT CATEGORY			
Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					